

Monday, May 16, 2016 10:10:19 AM

146273

Page 1

Accept

N900040100

Setup Start *NS1*

Item Name: Locknut

Stop *NS2*

Start Date: 5/16/2016 **Start Qty:** 25.00

~~*25*~~

Cust Item ID:

Required Date: 6/27/2016 **Req'd Qty:** 25.00

~~*25*~~

Customer:

Reference:

Approvals: Process Plan: ML5

Date: MAY 16 2016

Tooling:

Date:

Run Start *NR1*

QC:

Date:**SPC (Y/N):**

Date:

Stop ***NR2***

[illegible]

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
		OTHER : ☐							

Work Order ID 146273

Monday, May 16, 2016 10:10:19 AM

146273

Page 2

Item ID: D3015-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Locknut

Start Date: 5/16/2016 Start Qty: 25.00

25

Cust Item ID:

Required Date: 6/27/2016 Req'd Qty: 25.00

25

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>ST05 A</u>	0.00							
130									
Packaging	Memo	0.25				<u>200</u>	<u>DAS</u> <u>6</u> <u>9-89</u>		<u>MAY 25 2016</u>
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	2.50							
Quality Control									

16/5/25 JSMLS MAY 25 2016

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause				FAULT CATEGORY					
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐								
Misidentified ☐	Past Due ☐	OTHER :							

Picklist Print

Monday, May 16, 2016 10:10:19 AM

Page 1

Work Order ID: 146273

146273

Parent Item: D3015-3

D3015-3

Parent Item Name: Locknut

Start Date: 5/16/2016

Required Date: 6/27/2016

Start Qty: 25.00

Required Qty: 25.00

Comments: IPP: A01.06.28New IssueSM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
PFS-LNNC5/16S1		Purchased	No			110	Each	0.0000	1	25 100			
PFS-I NNC5/16S1										**			
Lock Nut													

MAY 24 2016

DAS
6
2016

DQA: _____ Date: _____



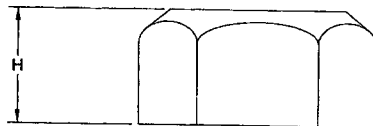
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QS1042) Approval		
Description Work Order Deviation				Disposition				Completed By	
								Lead hand / Supervisor Approval Verification	
								QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY							
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐				
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____							
Misidentified ☐	Past Due ☐								

SPECIFICATION CONTROL DRAWING



D3015-X LOCKNUT

PART NUMBER	SIZE	HEIGHT H	POSSIBLE SUPPLIER
D3015-1	1/4-20 UNC	0.31	ACKLANDS, P/N PFSLNNC14S1
D3015-3	5/16-18 UNC	0.34	ACKLANDS, P/N PFSLNNC516S1
D3015-5	7/16-14 UNC	0.46	ACKLANDS, P/N PFSLNNC716S1
D3015-7	M5	0.19	ACKLANDS, P/N FLMN021-005-0000



NOTES:

- 1) MATERIAL: SS LOCKNUT WITH NYLON INSERT
- 2) FINISH: N/A
- 3) TOLERANCES: ALL DIMENSIONS SHOWN AS REFERENCE
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A

SIZE OF COPY
RETURN TO
PART NUMBER
CONTROLLED COPY
SUBJECT TO AMENDMENT
WITH NOTICE
VOID IN ORDER

146-273 M/L
16-05-16

RELEASED
09/07/08

C	REFORMAT DWG. -7 P/N NOW FLMN021-005-0000 WAS LNNM5S1 (ZN B8-1), PAR 09-020	CP	09.07.08
B	ADD D3015-7	KJ	03.07.15
A	NEW ISSUE	DS	01.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	09.07.08		
DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3015 REV. C TITLE LOCKNUT SCALE NTS SHEET 1 OF 1 COPYRIGHT © 2001 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			



ACKLANDS-GRAINGER INC.
4475 GRIFFITH

SAINT-LAURENT QC H4T 2A2
(514) 332-8100
www.acklandsgrainger.com

Acklands-Grainger tax ID / N° taxe :
88970-1272/TVQ# 1019602903

Customer tax ID / N° taxe du client:

Contact / Contact:
LAVOIE (613)632-9577

PACKING SLIP / BORDEREAU D'EXPÉDITION

Customer PO / Du client PO:



PO32398

Sold to / Vendu à: 886364568
DART AEROSPACE LTD:

DART AEROSPACE LTD VMI
1270 ABERDEEN ST
HAWKESBURY ON K6A 1K7 CA

Ship to / Adresse d'expédition: 886364568

DART AEROSPACE LTD
DART AEROSPACE LTD VMI
1270 ABERDEEN ST
HAWKESBURY ON K6A 1K7 CA

Delivery / Livraison:



6324873708

1/2

Shipping conditions /
Conditions d'expédition:
Ship

Incoterms / Incoterms:

Free on board,ORIGIN

Payment terms / Conditions de
paiement:
Net 30 days after invoice date

Account manager / Directeur des
comptes:
350369

Order /
Commande
1262633727

Delivery date / Date d'envoi:

05/17/2016

Order date / Date de la
commande:
05/17/2016

Requisitioner / Demandeur:

Freight terms / Modalités de fret:
Prepaid and Add

Carrier / Transporteur:

Notes / Remarques:

Line / Ligne	PO line / Ligne de BC	Material / Matériau	Customer material / Matériau du client	Description / Description	Ship quantity / Quantité	Order quantity / Quantité commandée	UoM / Unité de mesure	Unit price / Prix unitaire	Per / Par	Extended price / Prix total
000010		FPBU51000.031.0150		CAPSCREW SS304 UNC 5/16-18X1-1/2	20.000	20.000	EA	27.45	100	5.49
000020		FPBU51205.031.0001		FLAT WASHER SS304 0.344X0.688	200.000	200.000	EA	3.38	100	6.76
000030		FPBU51700.031.0001		LOCKNUT NY RGL SS304 UNC 5/16-18	200.000	200.000	EA	10.14	100	20.28
000040		FPBU51205.043.0001		FLAT WASHER SS304 0.469X0.922	100.000	100.000	EA	5.75	100	5.75
00:00:00					Freight / Fret					0.00
					Subtotal / Total partiel					36.26
Received by / Recu par:					PST/QST / TVP/TVQ					0.00
					HST/GST / TPS/TVH					4.98
					Order total / Total de la commande					43.26

16/5/24
SY



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO32398**

Purchase Order Date 5/17/2016 12:40:54 PM

PO Print Date 5/17/2016

Page Number 1 of 2

Order From :

VC-ACK001

Ship To : DART AEROSPACE LTD

ACKLANDS - GRAINGER INC.
P.O. BOX 2970
WINNIPEG, MB R3C 4B5
CA

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

E-MAILED
MAY 17 2016

Contact Name

Vendor Phone 613 632 2739

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	5/16-18-015C acklands p/n: FPB U51000.031.0150	SS Bolt 5/16-181.5"K	5/24/2016 Yes 5/24/2016	FN	20.00 Each	\$0.27	\$5.49
Line Total:							\$5.49
2	5/16WC ACKLANDS P/N: FPB U51205.031.0001	Washer	5/24/2016 Yes 5/24/2016	FN	200.00 Each	\$0.03	\$6.76
Line Total:							\$6.76
3	PFS-LNNCS/16SI AS PER DWG D3015 REV. C B141898 ACKLANDS P/N: FPBU51738.031.0001	Lock Nut	5/24/2016 Yes 5/24/2016		200.00 Each	\$0.10	\$20.28

Note:

5/17/2016